

Work Order ID 126192 -1

October-31-14 11:59:09 AM

126192

Page 1

Item ID: 647.3914

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Breakaway Tip, Long

Start Date: 10/31/14 Start Qty: 24.00

24

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-10-31

Tooling:

Date:

Run Start *NR1*

QC: Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.3900	C

100		0.00							
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100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 14.500"

15/18

0

DAS
20
9-89

14-11-04

110		0.00							
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110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB315

DWG REV:

FOLIO REV: AA

15/18

0

DAS
20
9-89

14-11-05

2- deburr and break all sharp edges

Work Order ID 126192

126192

Page 2

October-31-14 11:59:09 AM

Item ID: 647.3914 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Breakaway Tip, Long
 Start Date: 10/31/14 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 11/07/14 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00				18	0		DAS 20 9-89 14-11-06
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00				15	0		DAS 37 9-89 14-11-06
130									
QC	Memo	0.00							
Quality Control									
140	Outsource process-Anodize per OSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O to ATG : <u>26433</u>								CX 14/11/10 15
	1- Black Anodize as per Dwg 647.3900								
	2- PRIME AS PER DWG, SEE NOTE #9								
	Certification of Comformity is required								

Work Order ID 126192

126192

October-31-14 11:59:09 AM

Page 3

Item ID: 647.3914 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Breakaway Tip, Long
 Start Date: 10/31/14 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 11/07/14 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>mtl</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								

15x 8014-11-12

15 5mfs 11/11/14

15 5mfs 11/11/14

Work Order ID 126192***126192***

October-31-14 11:59:09 AM

Page 4

Item ID: 647.3914 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Breakaway Tip, Long
Start Date: 10/31/14 Start Qty: 24.00 ***24*** Cust Item ID:
Required Date: 11/07/14 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

14/11/17

MF
14-11-14

Picklist Print

October-31-14 11:59:08 AM

Page 1

Work Order ID: 126192

126192

Parent Item: 647.3914

647.3914

Parent Item Name: Breakaway Tip, Long

Start Date: 10/31/14

Required Date: 11/07/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV. A NEW ISSUE JFS 14/06/19 VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B2.000X00.75 0		Purchased	No			100	f	25.4080	1.209	31			

M7075T6B2 000X00 750

7075-T6 BAR 2.000' X 0.750"

24.000'

DAS
20
9-89

14-11-04

Pull out of
stock
(nothing left)

Location

MAT028

M130312

MAT049

123555

M127736

Loc Qty

24

24

1.408

0.666

0.742

Loc Code

24.000

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04556

SHEET 1 OF 1

DWG NO. 647.3900

REV: C

PREPARED BY D. MEJIA

DATE: 06/10/2014

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: DEFLECTORS

APPROVED BY:

ENGR

MFG

QC

EFF.

NEXT ORDER

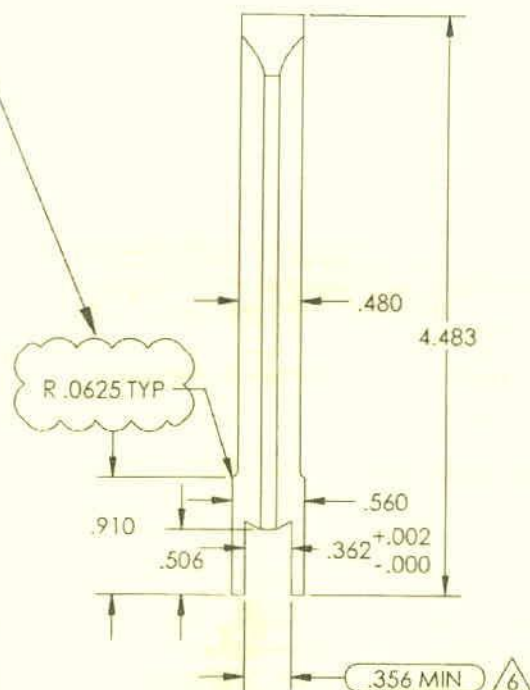
TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: DIMENSION CHANGE

ECR:

D-14-04

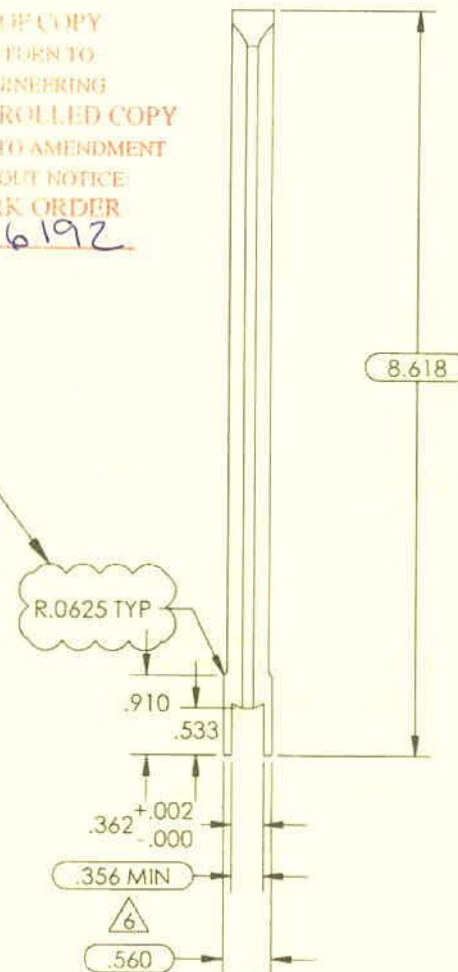
IS



SHEET 5, ZONE C6 IS:

IS

SHUP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 126192



SHEET 6, ZONE C6 IS:

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

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NOTES:

1. MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.

2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK.

3. DEBURR AND BREAK ALL SHARP EDGES.

4. IDENTIFY IAW MPP-120.

5. APPLY F/N 3 AS REQUIRED TO ALL FAYING SURFACES OF F/N 6, 7 & 8 UPON ASSY.

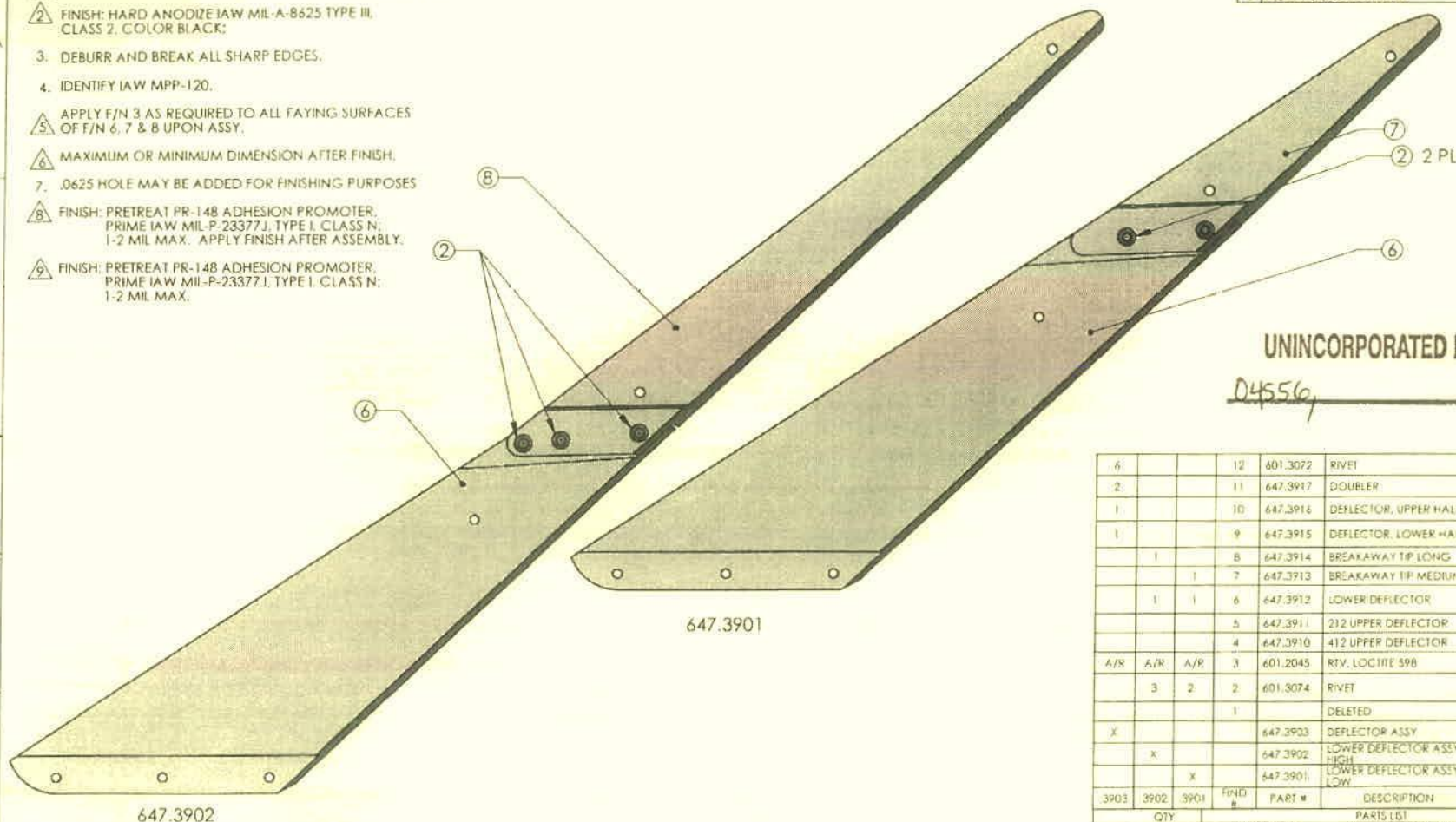
6. MAXIMUM OR MINIMUM DIMENSION AFTER FINISH.

7. .0625 HOLE MAY BE ADDED FOR FINISHING PURPOSES.

8. FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N, 1-2 MIL MAX. APPLY FINISH AFTER ASSEMBLY.

9. FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N, 1-2 MIL MAX.

REV	DESCRIPTION	DATE	APPROVED
REV	(AUTO PROTOTYPE RELEASE-FR)		WAC
REV	REVISION	07/04/00	P. BRAY
A	INCORPORATED ECN 2064 8/30/01	07/24/01	P. BRAY
B	INCORPORATED ECN 2403	08/01/01	P. BRAY
C	INCORPORATED ECN 2408, 2416 & 2419	11/16/01	P. BRAY



6			12	601.3072	RIVET	CR2013-69	
2			11	647.3917	DOUBLER		
1			10	647.3916	DEFLECTOR, UPPER HALF	△	△
1			9	647.3915	DEFLECTOR, LOWER HALF	△	△
	1		8	647.3914	BREAKAWAY TIP LONG	△	△△
		1	7	647.3913	BREAKAWAY TIP MEDIUM	△	△△
	1	1	6	647.3912	LOWER DEFLECTOR	△	△△
			5	647.3911	212 UPPER DEFLECTOR	△	△△
			4	647.3910	412 UPPER DEFLECTOR	△	△△
A/R	A/R	A/R	3	601.2045	RIV. LOCITE 598		△
	3	2	2	601.3074	RIVET	MODIFIED 6/12	
			1		DELETED		
X				647.3903	DEFLECTOR ASSY		△
X	X			647.3902	LOWER DEFLECTOR ASSY HIGH		
		X		647.3901	LOWER DEFLECTOR ASSY LOW		
3903	3902	3901	END	PART #	DESCRIPTION	MATL	SPEC
QTY				PARTS LIST			
NEXT ASSY (S)				ORIGINAL DATA			
647.3800				UNO (S) (S)			
				DRAWN BY			
				CHECKED BY			
				DESIGNED BY			
				CONTRACT NO.			
				UNLESS OTHERWISE SPECIFIED			
				DIMENSIONS ARE IN INCHES			
				TOLERANCES ARE			
				FRACTIONS DECIMALS ±.01			
				ANGLES ±.5°			
				HATCH: P. 17			
				APICAL INDUSTRIES			
				2608 TEMPLE HEIGHTS DR.			
				OCEANSIDE, CA. 92056-3512 (760) 724-5300			
				DEFLECTORS			
				REV. 647.3900			
				SCALE: NONE			
				SHEET 1 OF 12			

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.125 X 45.0° TYP

SECTION B-B

Ø.177 THRU 3PL

.266 X 17.9°

DETAIL A

DETAIL C

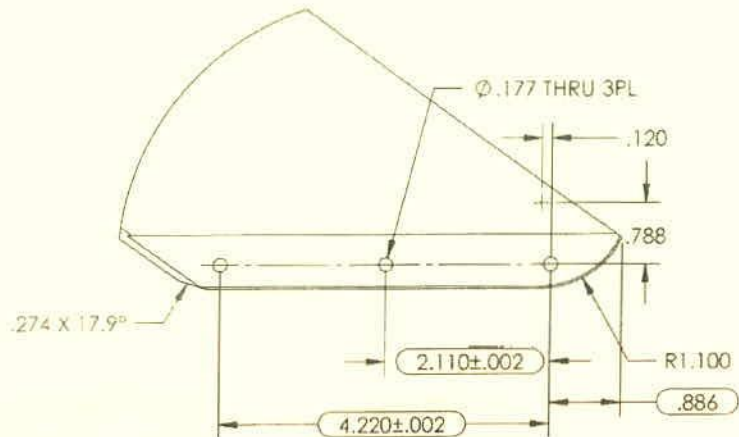
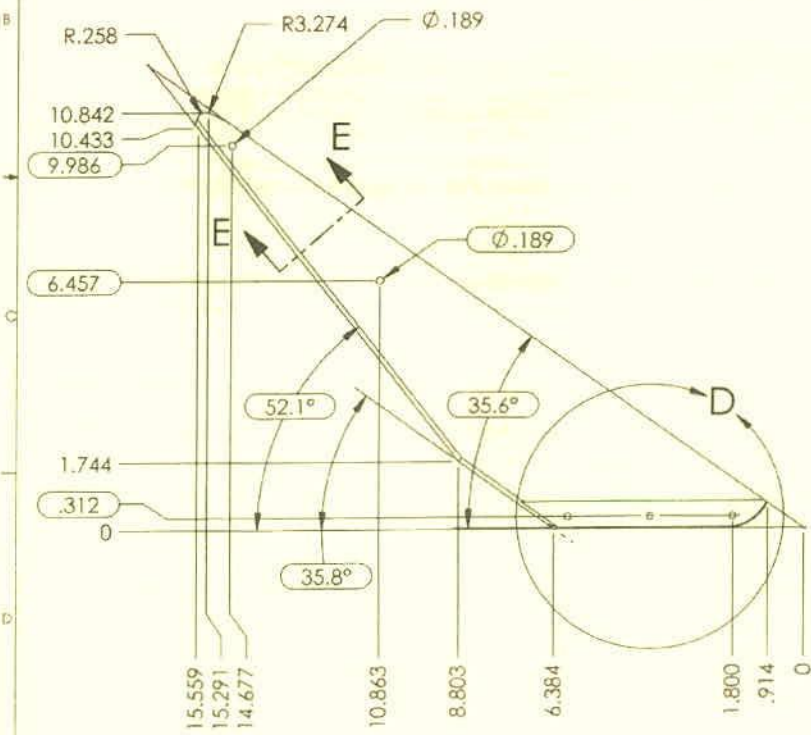
647.3911

SPECIAL DATE METHOD (S) REVIEWER DATE DRAWING APPROVAL P. 0000 C. 0000		APICAL INDUSTRIES 2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300	
PARTS CHANGES SPECIFIED (DATE/REVISION/REASON) 1. 0000 0000 0000 2. 0000 0000 0000 3. 0000 0000 0000		SEE CASE CODE B / 01/01/01	REV C
SCALE: NONE		647.3900	SHEET 2 OF 12

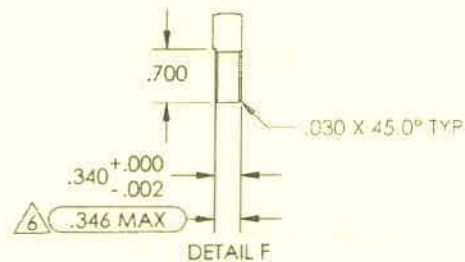
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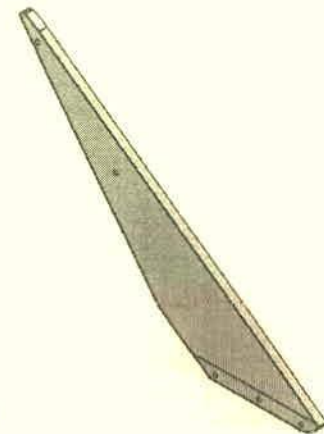
SECTION E-E



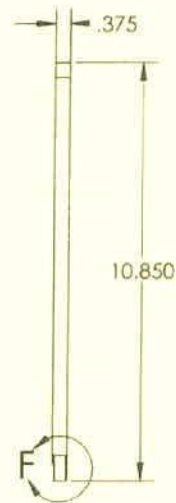
DETAIL D



DETAIL F

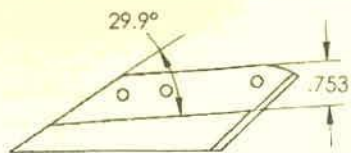


647.3910

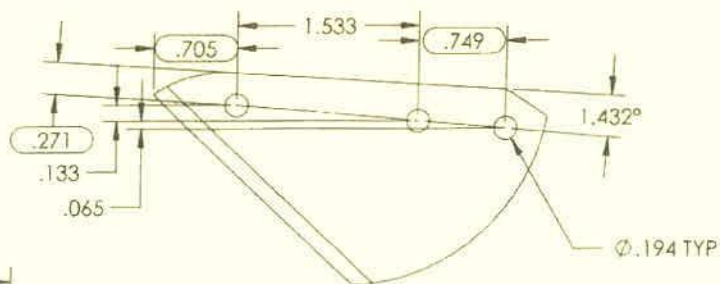


ORIGINAL DATE: 01/01/00 DRAWN BY: J. B. BOWEN CHECKED BY: J. B. BOWEN DESIGNED BY: J. B. BOWEN APPROVED BY: J. B. BOWEN COMMENTS:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
PARTS DIFFERENCES SPECIFIED MANUFACTURED IN THE U.S.A. TO EXCEED ALL TYPICAL DEFLECTOR ANGLES: 1.0°		DEFLECTOR CODE: B CNAME: 647.3900 SCALE: 1/10"=1"	REV: C SHEET: 3 OF 12

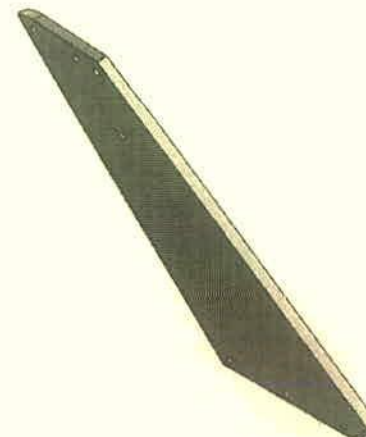
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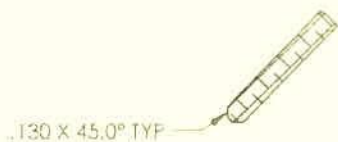
SECTION L-L



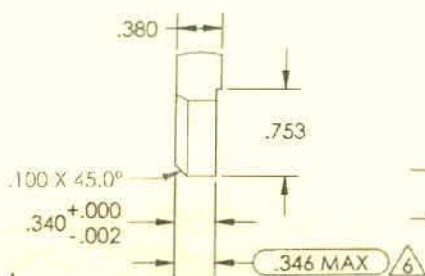
DETAIL H



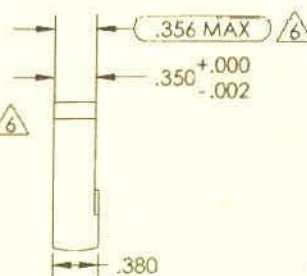
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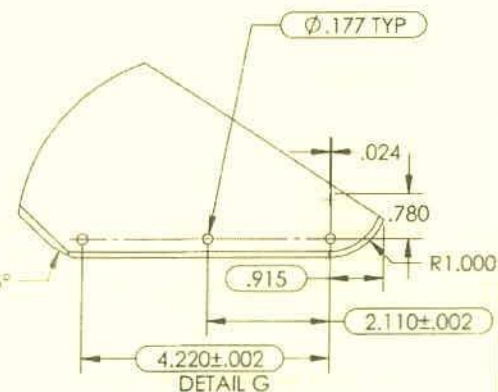
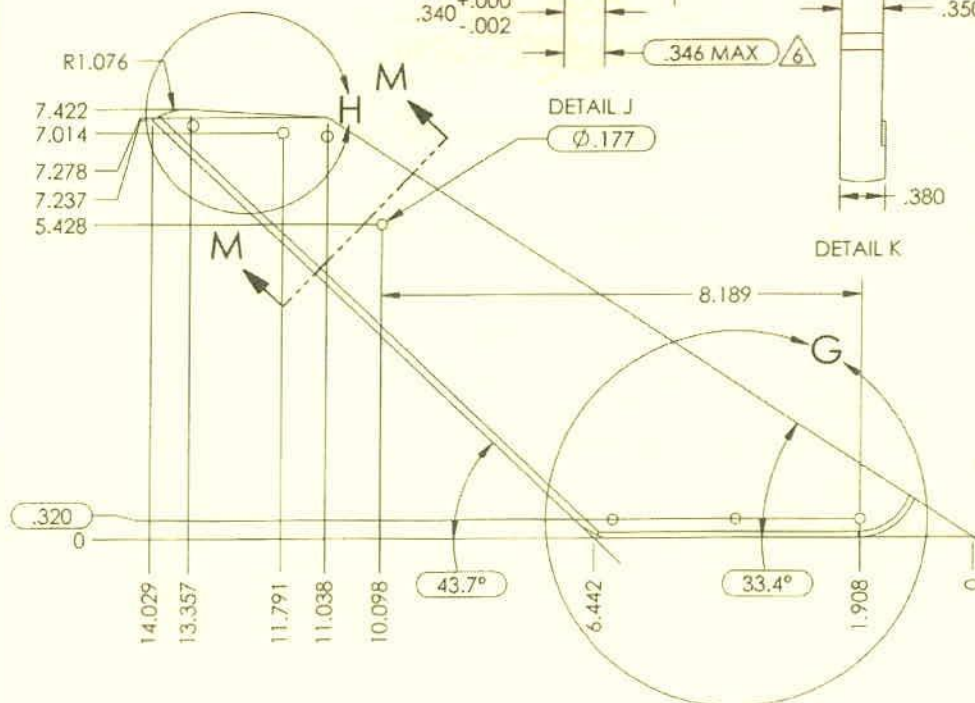
SECTION M-M



DETAIL J



DETAIL K



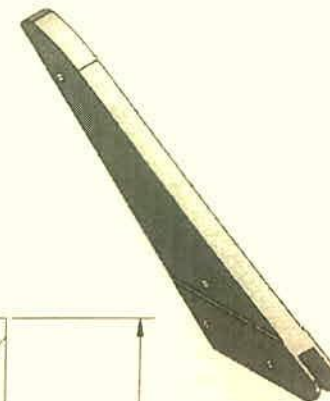
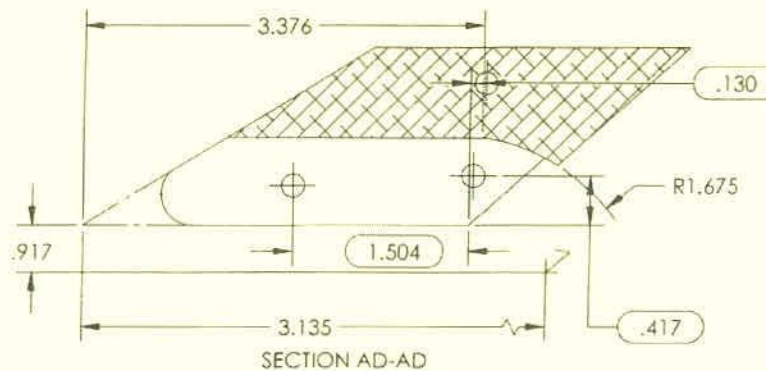
DETAIL G

APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300	
DEFLECTORS	
PART NO. 647.3900 SCALE: NONE	SHEET 4 OF 12

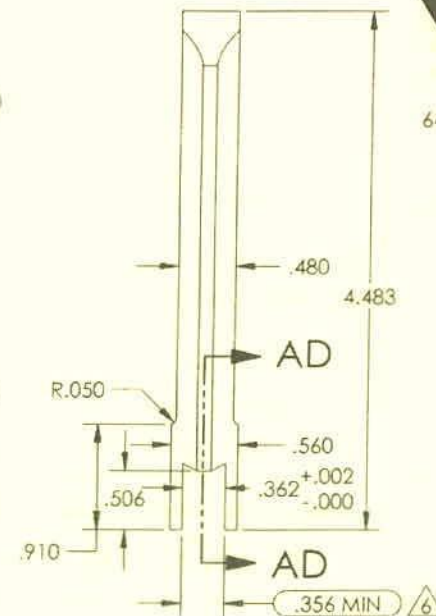
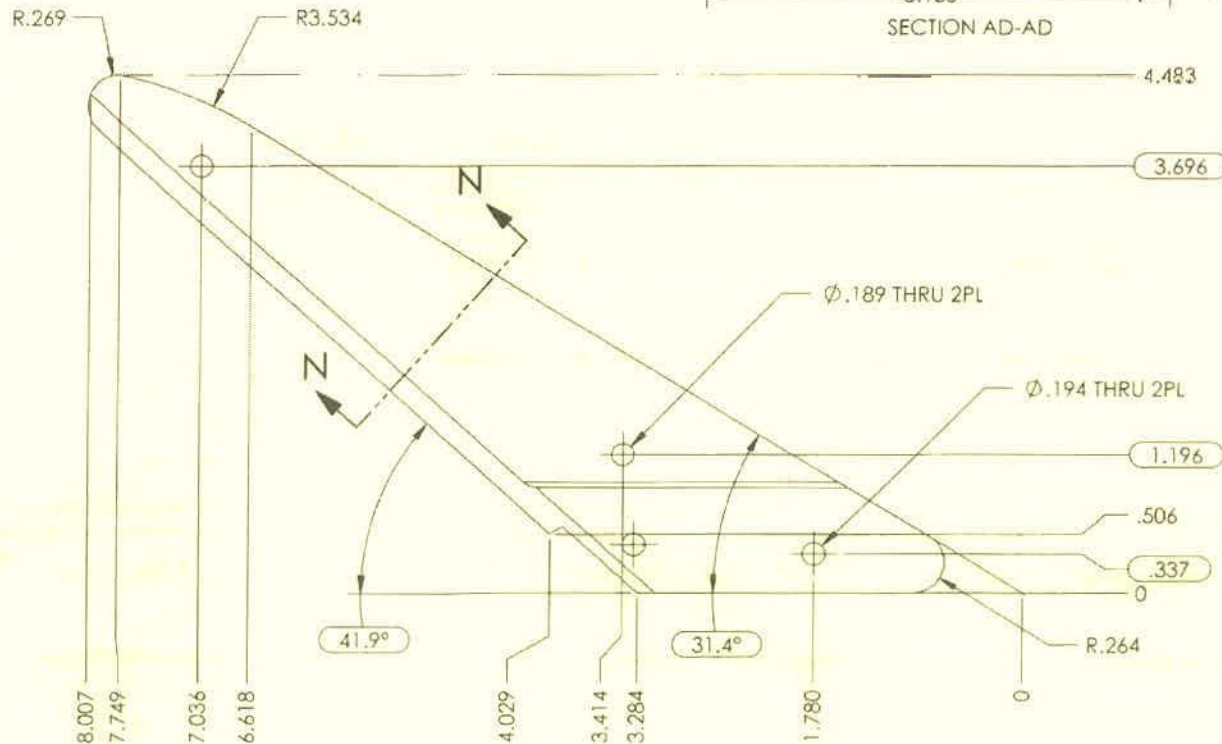
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.180 X 45.0° TYP

SECTION N-N



647.3913



ORIGINAL DATE	2003-11-11	DESIGNED BY	DAVID L. WILSON
DRAWN BY	DAVID L. WILSON	CHECKED BY	DAVID L. WILSON
APPROVED BY	DAVID L. WILSON	DATE	2003-11-11
REVISIONS			
1. CHANGE DIMENSIONS TO .356 MIN			
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APICAL INDUSTRIES

2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA 92056-3512 (760)724-5300

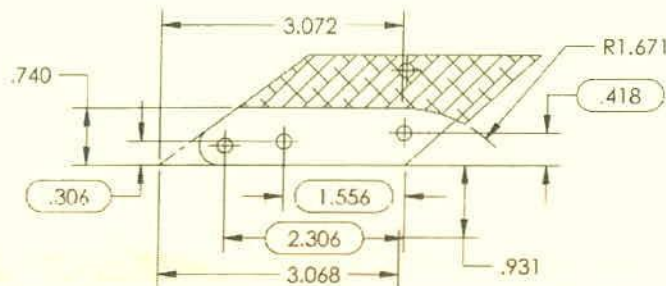
DEFLECTORS

DET: (PAGE 000) SHEET: 13
8 07/02/06 647.3900
SCALE: NONE SHEET 5 OF 12

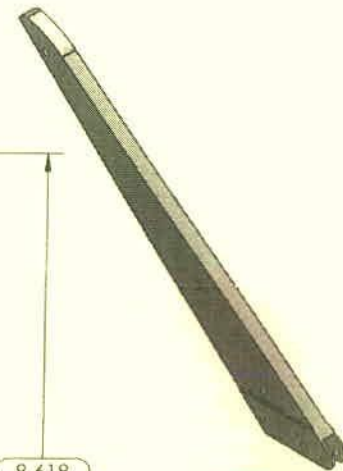
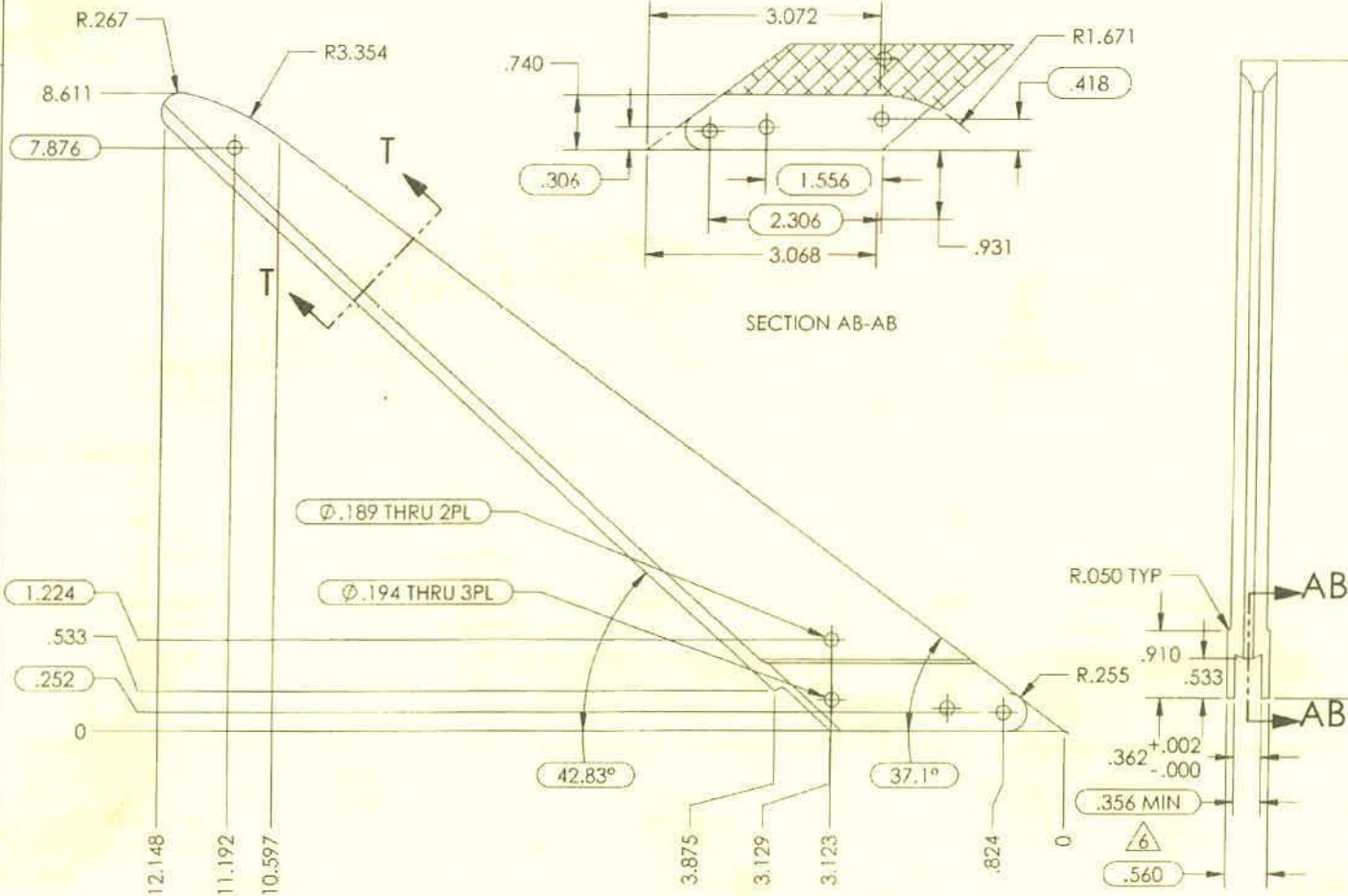
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.175 X 45.0° TYP

SECTION T-T



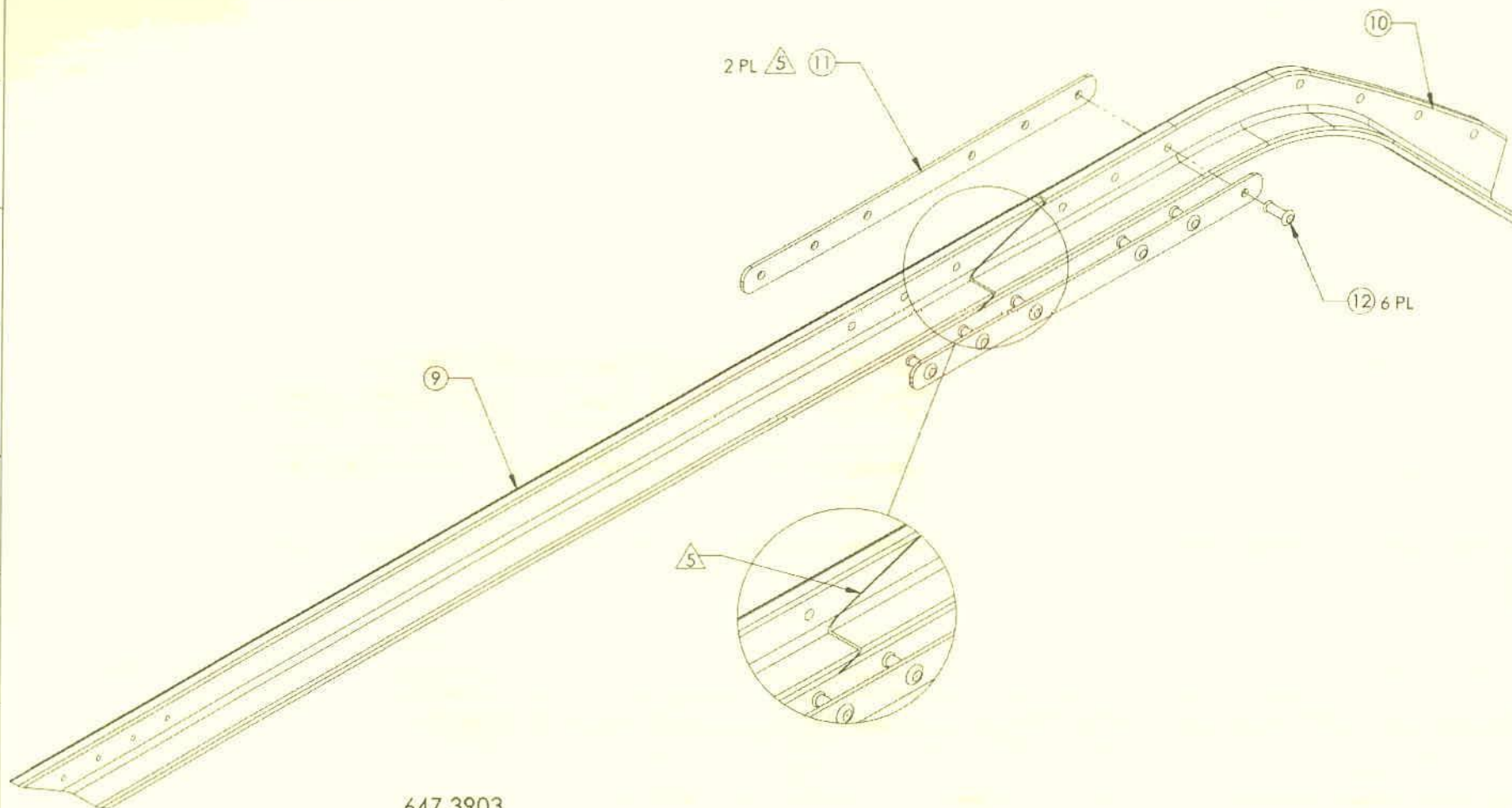
SECTION AB-AB



647.3914

ORIGINAL DATE: 01/30/08 DRAWN BY: J. BAKER CHECKED BY: J. BAKER DESIGNED BY: J. BAKER SCALE: NONE		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300	
PARTS LISTED HERE SPECIFIED: DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED		DEFLECTORS	
SEE: 07/20/06 B: 07/20/06	DWG. NO.: 647.3900	REV. C	SHEET 2 OF 12

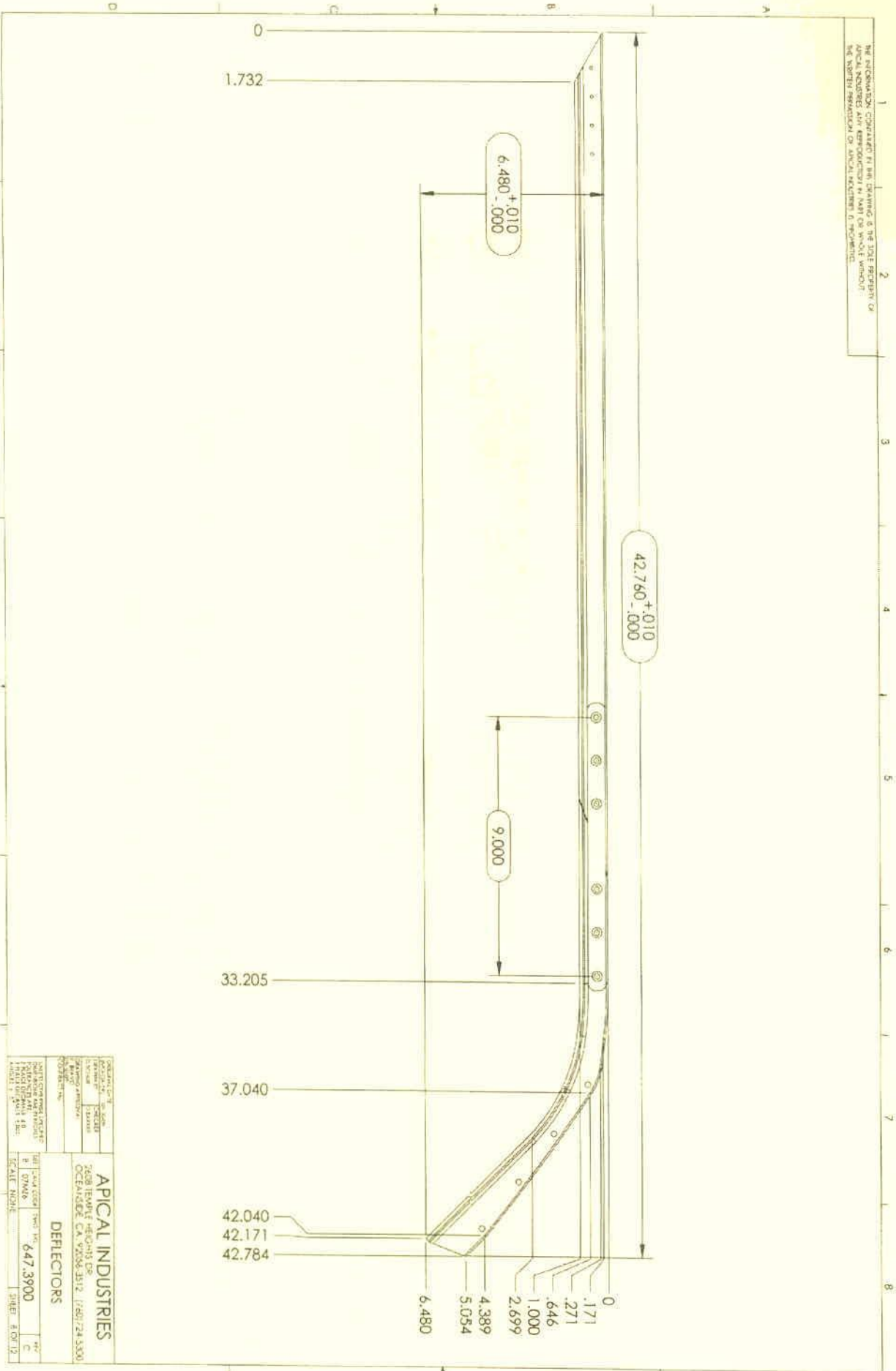
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647.3903

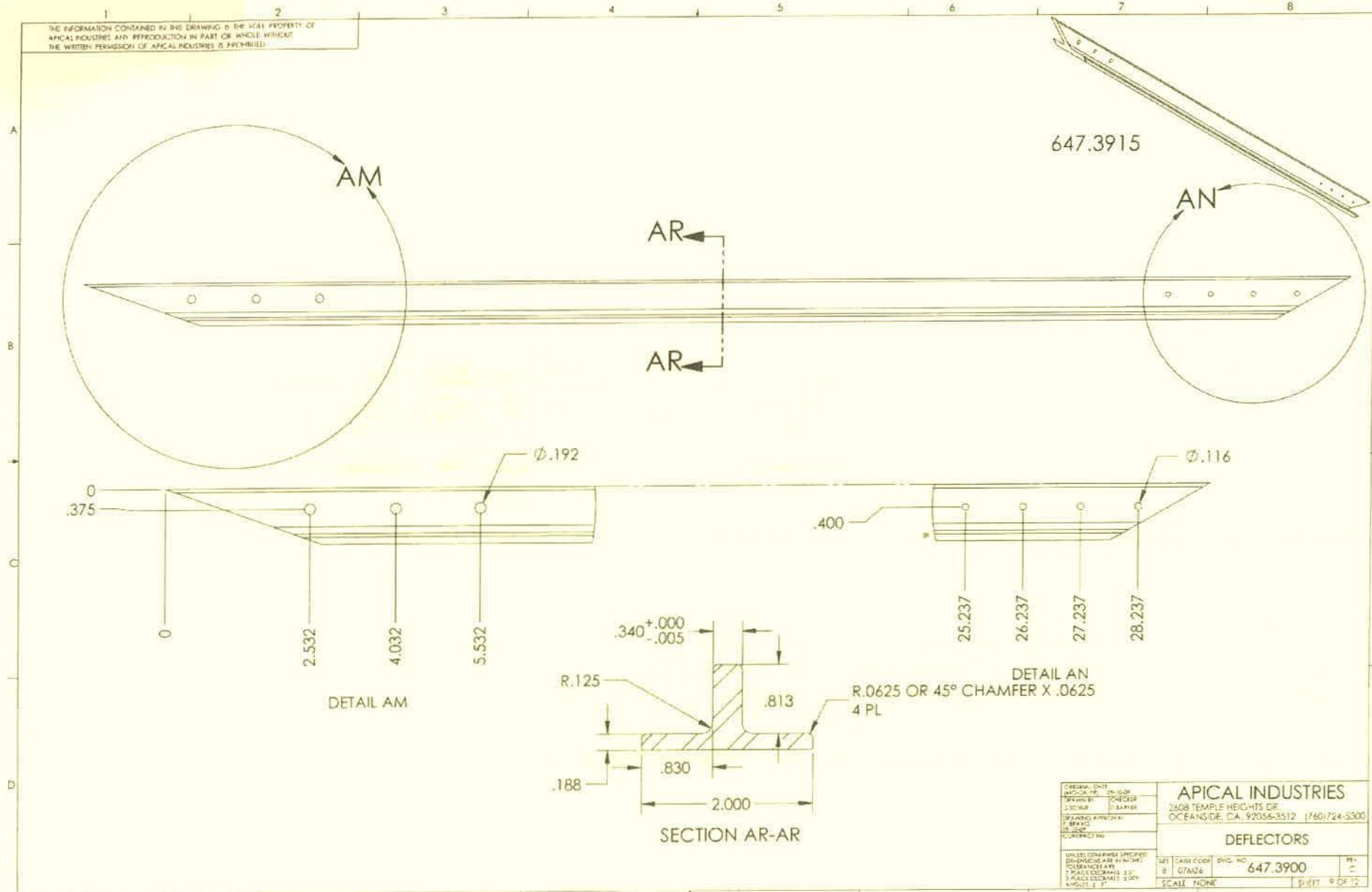
DATE: 10/10/00 DRAWN BY: J. L. COLE CHECKED BY: J. L. COLE DESIGNED BY: J. L. COLE APPROVED BY: J. L. COLE CONTRACT NO.:		APICAL INDUSTRIES 2500 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300	
BASIC DIMENSIONS SPECIFIED DIMENSIONS IN INCHES DIMENSIONS IN FEET DIMENSIONS IN METERS DIMENSIONS IN MILLIMETERS DIMENSIONS IN CENTIMETERS		DEFLECTORS	
SCALE: NONE		DWG. NO.: 647.3900	REV.: G
SHEET: 1 OF 1		SCALE: NONE	

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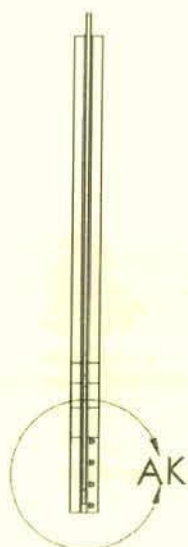
APICAL INDUSTRIES 2408 TEMPLE HEIGHTS DR OCEANIDE, CA 92056-3512 (760) 724-5300	
DRAWING NO. 100-100-100-100 SCALE: 1/8" = 1'-0" DATE: 10/1/80	SHEET NO. 100-100-100-100 TOTAL SHEETS: 100-100-100-100

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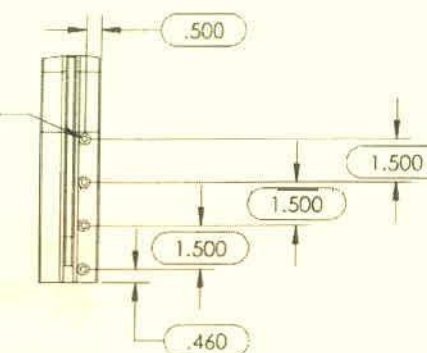


CREATOR: DAD APPROVAL: TPT DRAWING: 010000 DATE: 01/01/00 DRAWING APPROVAL: 010000 DATE: 01/01/00 CHECKED: 010000		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
MATERIALS: 304 STAINLESS STEEL FINISH: POLISHED TOLERANCES: .005 3 PLACE DECIMALS 2 DEC ANGLES: 1/2°		DEFLECTORS 647.3900 SCALE: NONE SHEET: 9 OF 10	

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4X $\phi .196 \pm .010$ THRU ALL
 $\checkmark \phi .385 \pm .020 \times 100^\circ \pm 1.000^*$



DETAIL AK

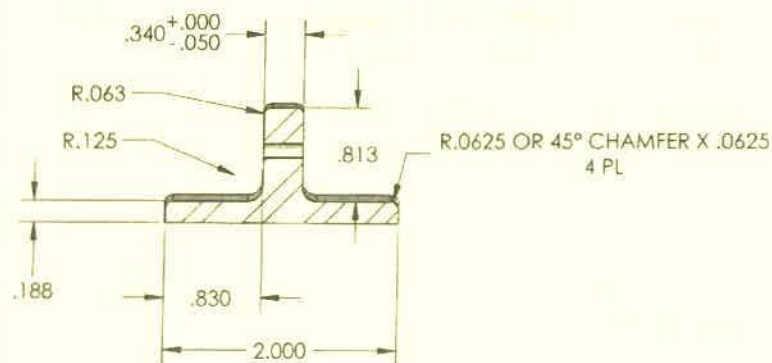
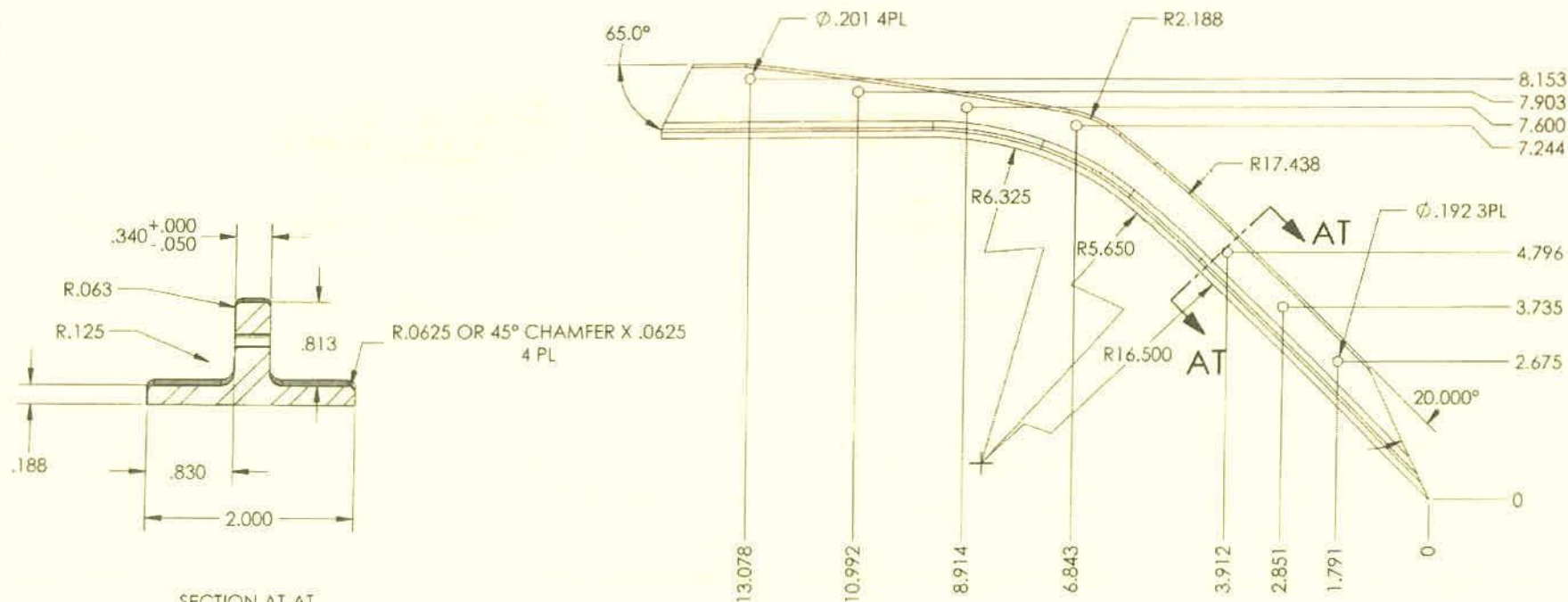
647.3915

ORIGINAL DATE: 08/11/09 DRAWN BY: J. SCHMIDT CHECKED BY: J. SCHMIDT DESIGNED BY: J. SCHMIDT P. REVISED: 08/11/09 P. CHECKED: 08/11/09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300	
ANALYSIS OF WORKING SPECIFIED: DIMENSIONS ARE IN INCHES UNLESS NOTED OTHERWISE 1. PLACES SPECIFIED 2. IN 3. UNLESS OTHERWISE SPECIFIED		SHEET NO. OF SHEETS B 07/04/09 SCALE: NONE	REV. C 647.3900 SHEET 10 OF 12

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647.3916



SECTION AT-AT

OFFICIAL DATA NAME OF THE PROJECT DRAWN BY CHECKED BY DATE PROJECT NO.		APICAL INDUSTRIES 2656 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
INLET OTHER SPECIFIED SPREADER (FEET INCHES) CURB (FEET INCHES) (PLANT DEFLECTOR) (2) (PLANT DEFLECTOR) (2) ANGLE 8° ST		DEFLECTORS SCALE: NONE SHEET 11 OF 12	
101 E 01/12/86	647.3900 C		

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647.9317

R.250
4 PL

.625

.090

Ø.196
6 PL

0

.500

2.000

3.500

6.500

8.000

9.500

10.000

DATE: 01/11/01
DESIGNED BY: J. H. H. H.
DRAWN BY: J. H. H. H.
CHECKED BY: J. H. H. H.
APPROVED BY: J. H. H. H.
CONTRACT NO.: J. H. H. H.

APICAL INDUSTRIES
2408 TEMPLE HEIGHTS OF
OCEANSIDE, CA 92086-3512 1/60/724-5300
DEFLECTORS
REV. C
SCALE: NONE
SHEET 12 OF 12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26433

Purchase Order Date 11/10/2014

PO Print Date 11/10/2014

Page Number 1 of 2

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED \$

Contact Name

Vendor Phone

613-446-4544

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

VENDOR'S TRUCK

FOB

FCA - (Free Carrier)

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
Line Comments			Promise Date				
Delivery Comments							

1	126192	647.3914 BREAKAWAY TIP REV. C	11/14/2014		15.00 ✓	\$11.55	\$173.25
			Yes				
			11/14/2014				

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$173.25

2	125594	D5171-041 NUT RING REV. PA2	11/14/2014		8.00 ✓	\$10.42	\$83.36
			Yes				
			11/14/2014				

FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2
COLOR: RED

Line Total: \$83.36

Note:

11/10/2014



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63380

Date: 12-Nov-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

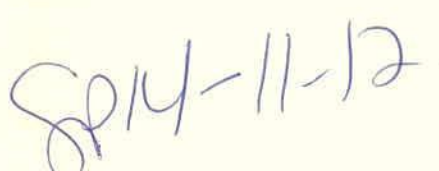

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms	Ship Via
Quantity	Description
15 ea	Part: 647.3914 Rev: HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT SUPPLIED BY CUSTOMER Job: 20140776 PO: PO26433 Line: 
1 lot	Part: D5171-041/D5174-1 Rev: RED ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20140777 PO: PO26433 Line:
<p>Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p>ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE: <u>12/11/14</u></p> <p>CERTIFIED SIGNATURE: <u></u></p> <p>RECEIVER SIGNATURE: _____</p>	